

G-6807686

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

BM FORM

proof of purchase



owner registration sticker



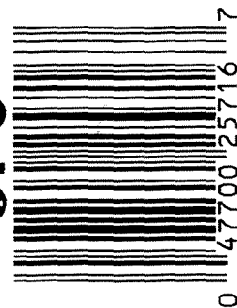
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6807686

UPC



GUN SERIAL #

G6807686

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-20-09	RP
430	ASSEMBLE TO STOCK		3-20-09	RP
440	PROOF		3-20-09	RP
460	CHECK HEADSPACE		3-20-09	RP
470	DIS-ASSEMBLE ACTION		3-20-09	RP
472	SERIALIZE BOLT HANDLE		3-23-09	RP
475	DRILL AND TAP SIGHT HOLES		3-23-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR (D)	3/25/09	(D)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3/25/09	RT
520	GOFF BLAST BBL / REC		3-25	BH
542	APPLY COATINGS (BARREL ACTION)		3-28	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-30-09	TL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-30-09	TL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-30-09	TL
	D) OIL FIRING PIN ASSEMBLY		4-2-09	RP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		
F004 REV 5/2006				

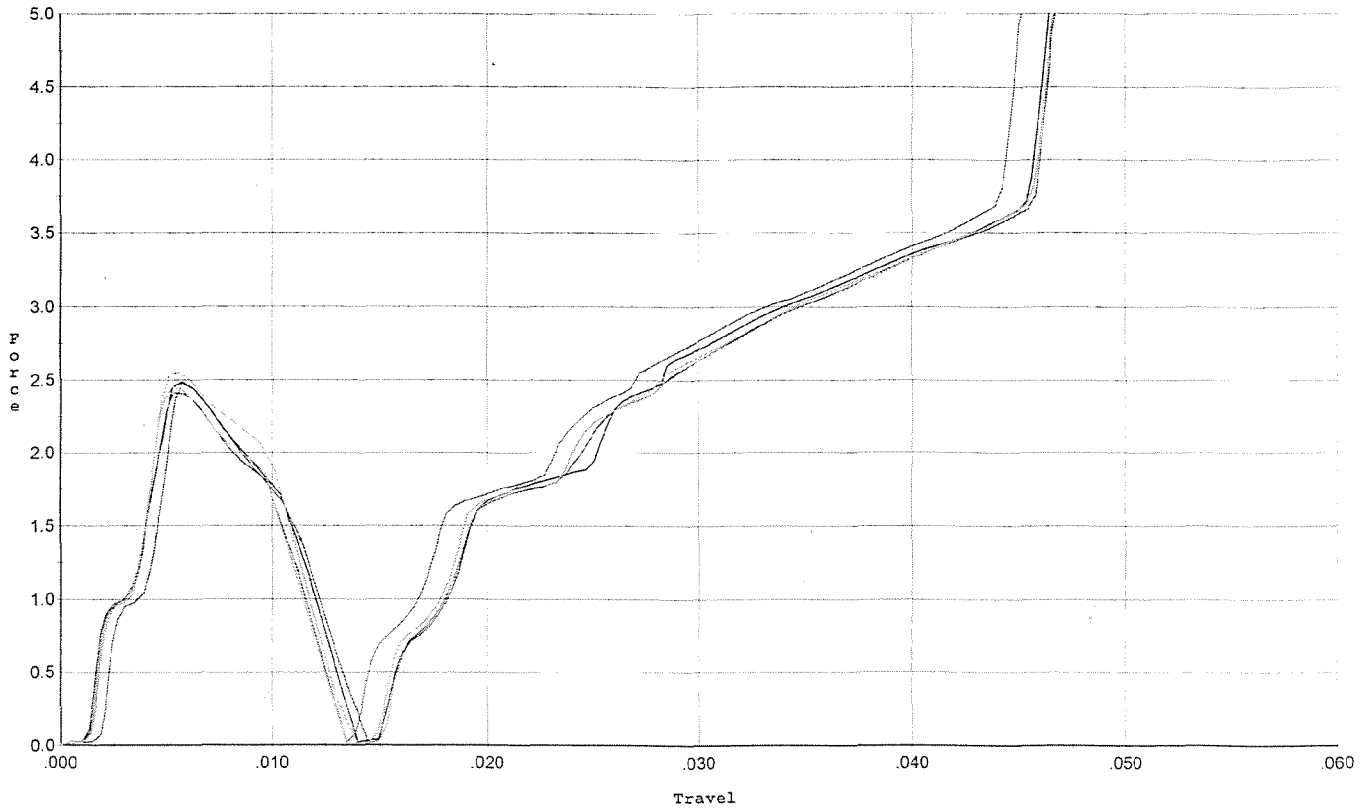
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6</u> <u>6</u> <u>6</u>	4-17-09	W W
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4</u> <u>4</u> <u>4</u>	4-17-09	W W
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.023</u> <u>.025</u>	4-17-09	W W
	J) ASSEMBLE STOCK		4-2-09	L. J.
	K) ASSEMBLE SWIVEL STUDS		4-17-09	W W
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			
	M) IRON SIGHT ALIGNMENT			
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> <u>FAIL</u> <u>PASS</u> <u>FAIL</u>	4-7-09	W W
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		4-7-09	TAR
670	FINAL INSPECTION A) HEADSPACE		4-17-09	W W
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.58</u> <u>2.56</u> <u>2.62</u> <u>2.51</u> <u>2.50</u>	4-14-09	W W
	C) FUNCTION		4-17-09	W W
690	PACK		5/30/09	Fay

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/28/2009

Model: M/24
Serial No: Form #F005
Trigger: 2.5 lbs ini +/- .50 lb



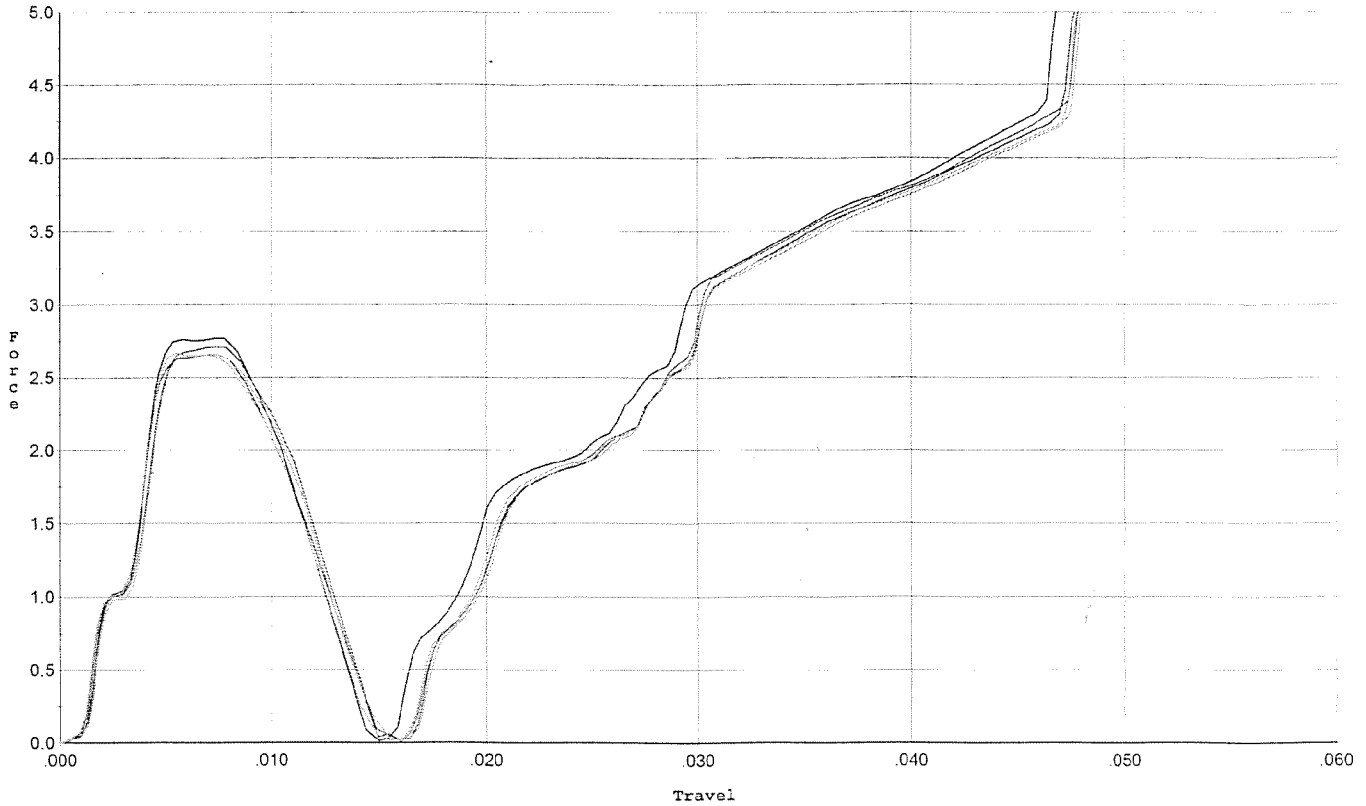
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.477	0.011	0.00	0.038	0.015		Set Trigger
2	2.482	0.012	0.00	0.038	0.017		Set Trigger
3	2.412	0.011	0.00	0.037	0.015		Set Trigger
4	2.451	0.010	0.00	0.039	0.014		Set Trigger
5	2.555	0.010	0.00	0.039	0.015		Set Trigger

A-2-47

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/28/2009

Model: M/24
 Serial No: Form #F005
 Trigger: 2.5 lbs after 50 cycles+/- .50 lb



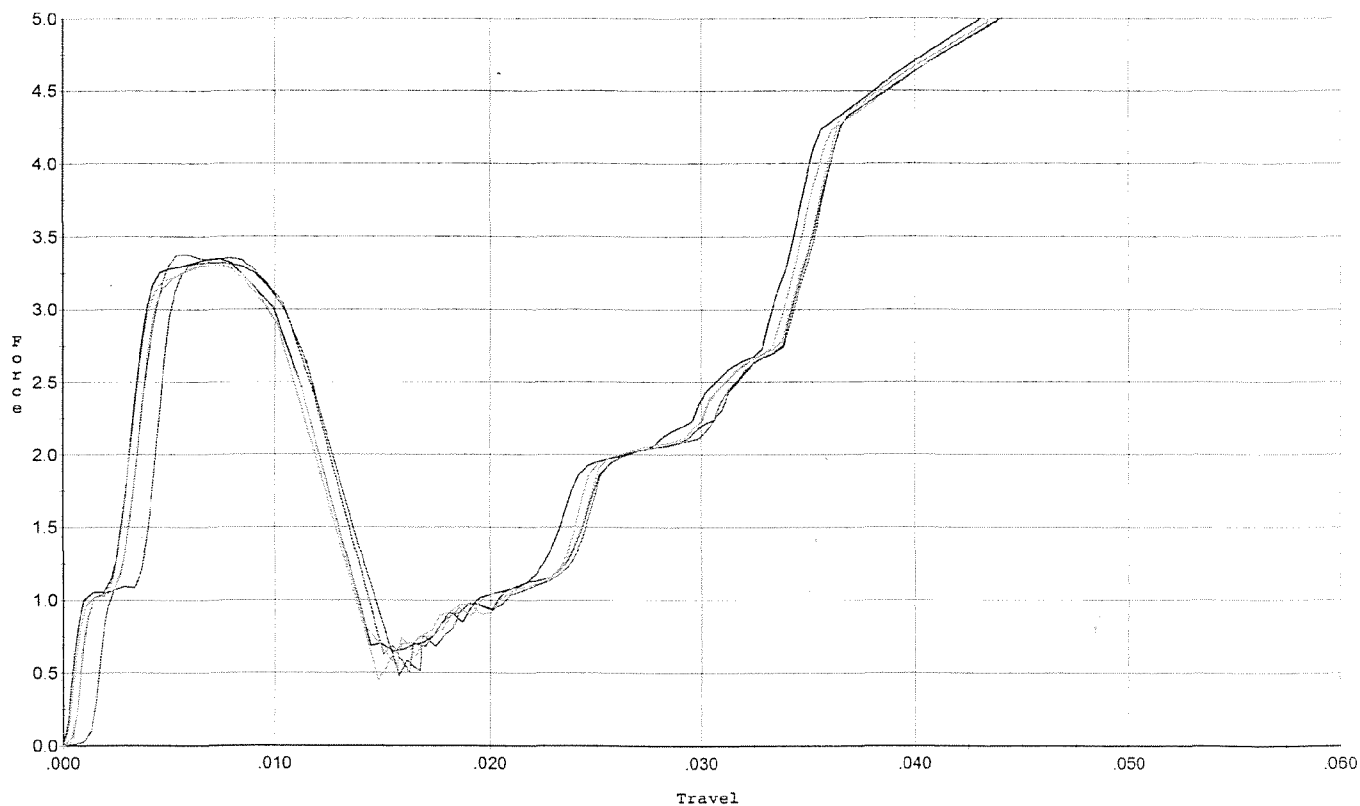
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.655	0.013	0.00	0.037	0.022		Set Trigger
2	2.771	0.012	0.00	0.037	0.020		Set Trigger
3	2.713	0.011	0.00	0.038	0.018		Set Trigger
4	2.672	0.012	0.00	0.038	0.020		Set Trigger
5	2.659	0.011	0.00	0.038	0.018		Set Trigger

A-2.69

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/28/2009

Model: M/24
Serial No: Form #F005
Trigger: 3.0 lbs ini +/- .75 lb



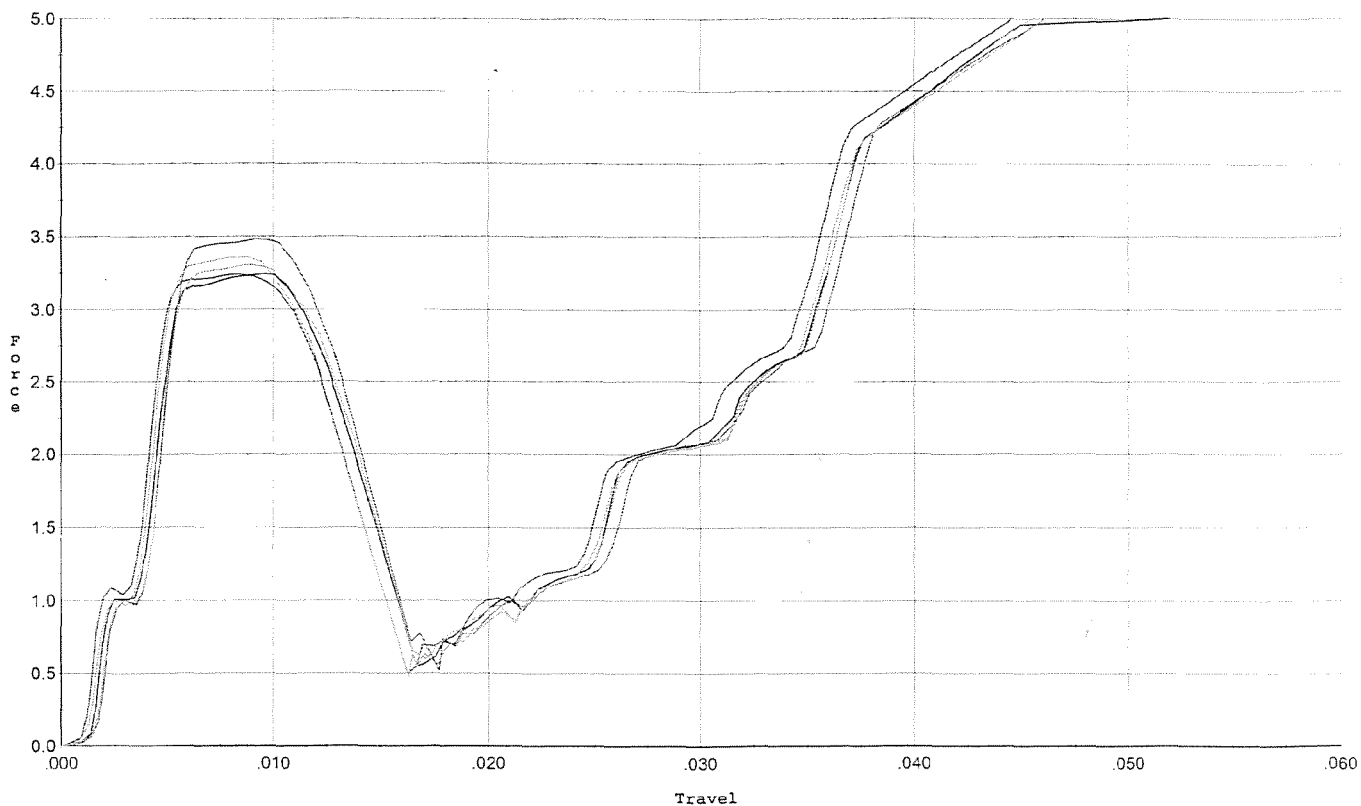
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.318	0.011	0.00	0.038	0.023		Set Trigger
2	3.351	0.011	0.00	0.038	0.025		Set Trigger
3	3.377	0.012	0.00	0.038	0.026		Set Trigger
4	3.332	0.011	0.00	0.038	0.024		Set Trigger
5	3.307	0.012	0.00	0.038	0.027		Set Trigger

A-3-33

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/28/2009

Model: M/24
 Serial No: Form #F005
 Trigger: 3.0 lbs after 20 cycles+/- .75 lb



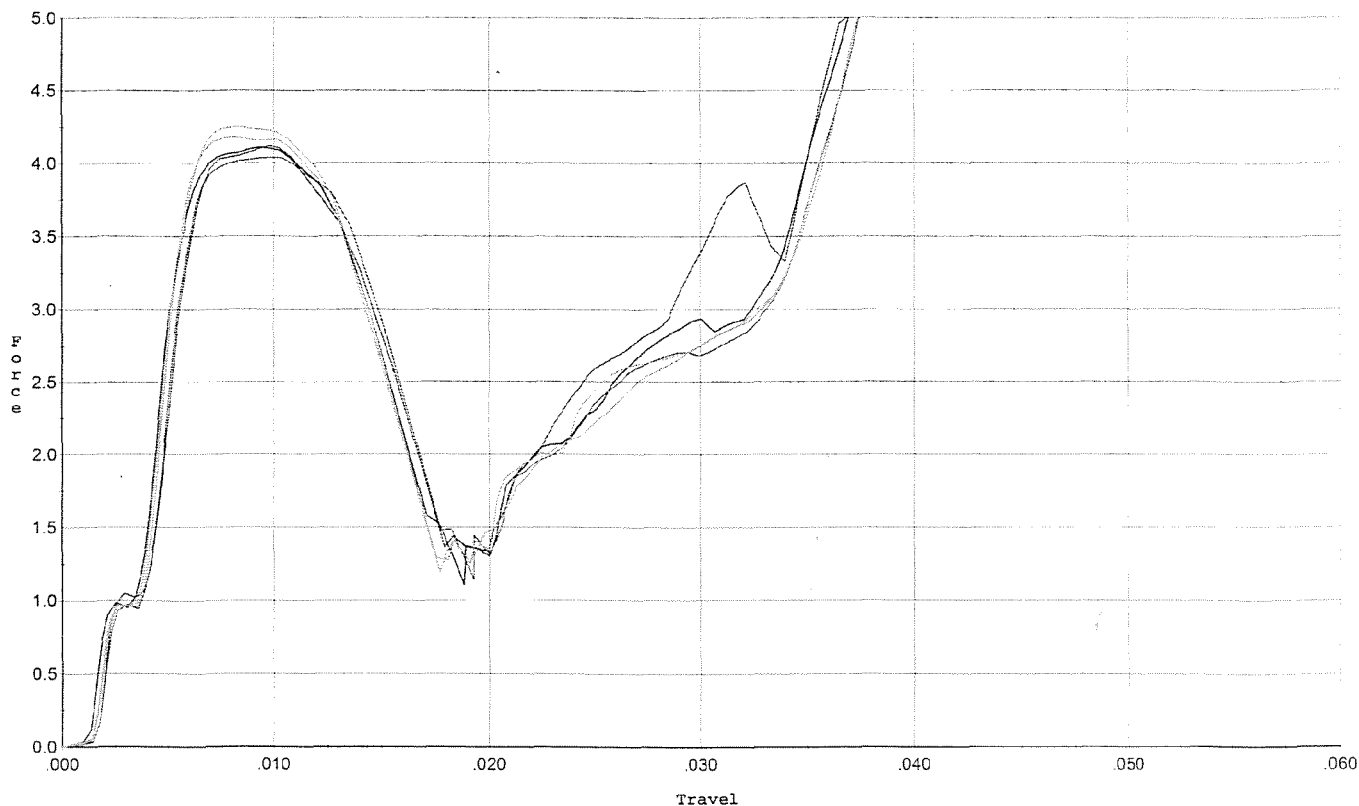
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.241	0.012	0.00	0.038	0.025		Set Trigger
2	3.243	0.014	0.00	0.038	0.029		Set Trigger
3	3.484	0.013	0.00	0.038	0.027		Set Trigger
4	3.306	0.014	0.00	0.038	0.028		Set Trigger
5	3.358	0.012	0.00	0.039	0.024		Set Trigger

A-3-32

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/28/2009

Model: M/24
Serial No: Form #F005
Trigger: 4.0 lbs ini +/- 1.0 lb



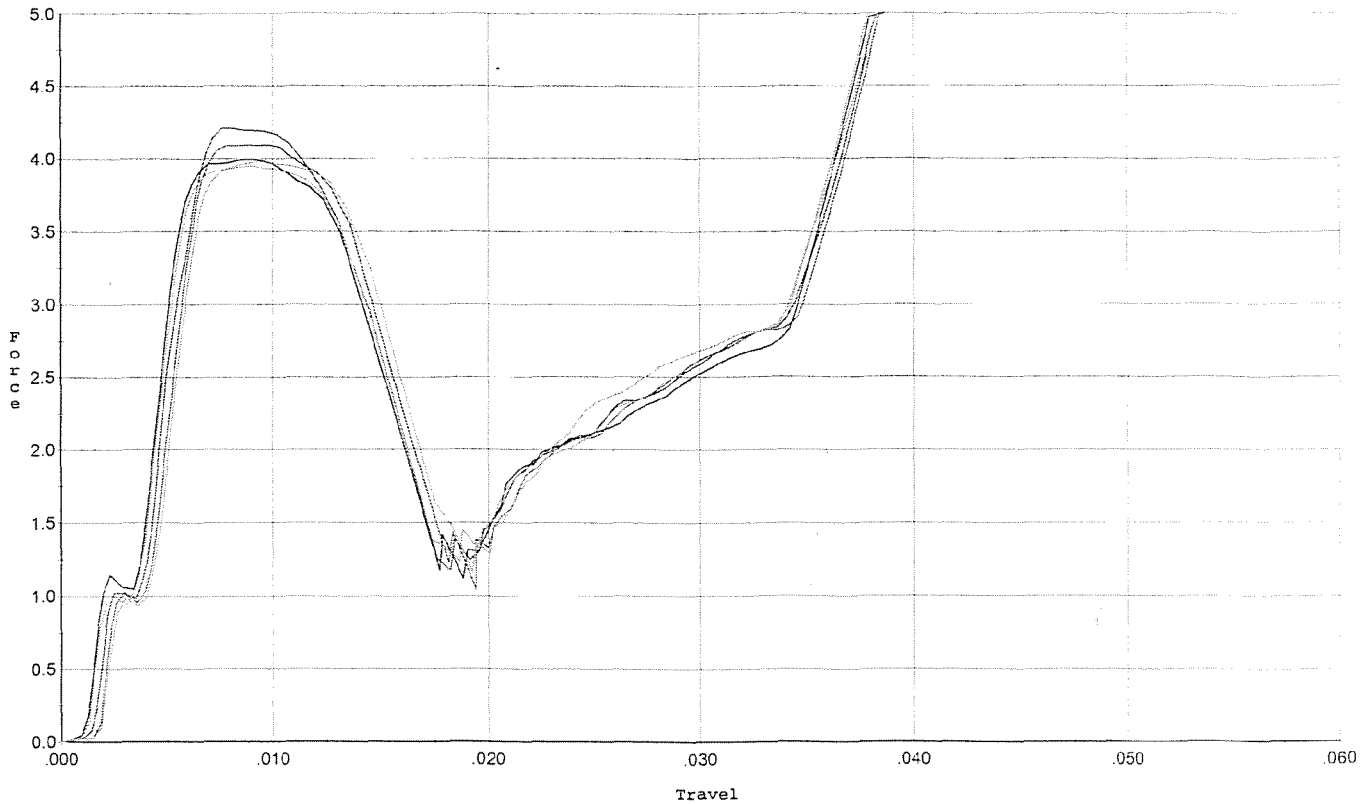
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.118	0.016	0.00	0.025	0.038		Set Trigger
2	4.108	0.014	0.00	0.025	0.037		Set Trigger
3	4.038	0.015	0.00	0.025	0.037		Set Trigger
4	4.180	0.015	0.00	0.026	0.038		Set Trigger
5	4.250	0.014	0.004	0.026	0.037		Set Trigger

A. 4.13

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/28/2009

Model: M/24
Serial No: Form #F005
Trigger: 4.0 lbs after 20 cycles+/- 1.0 lb



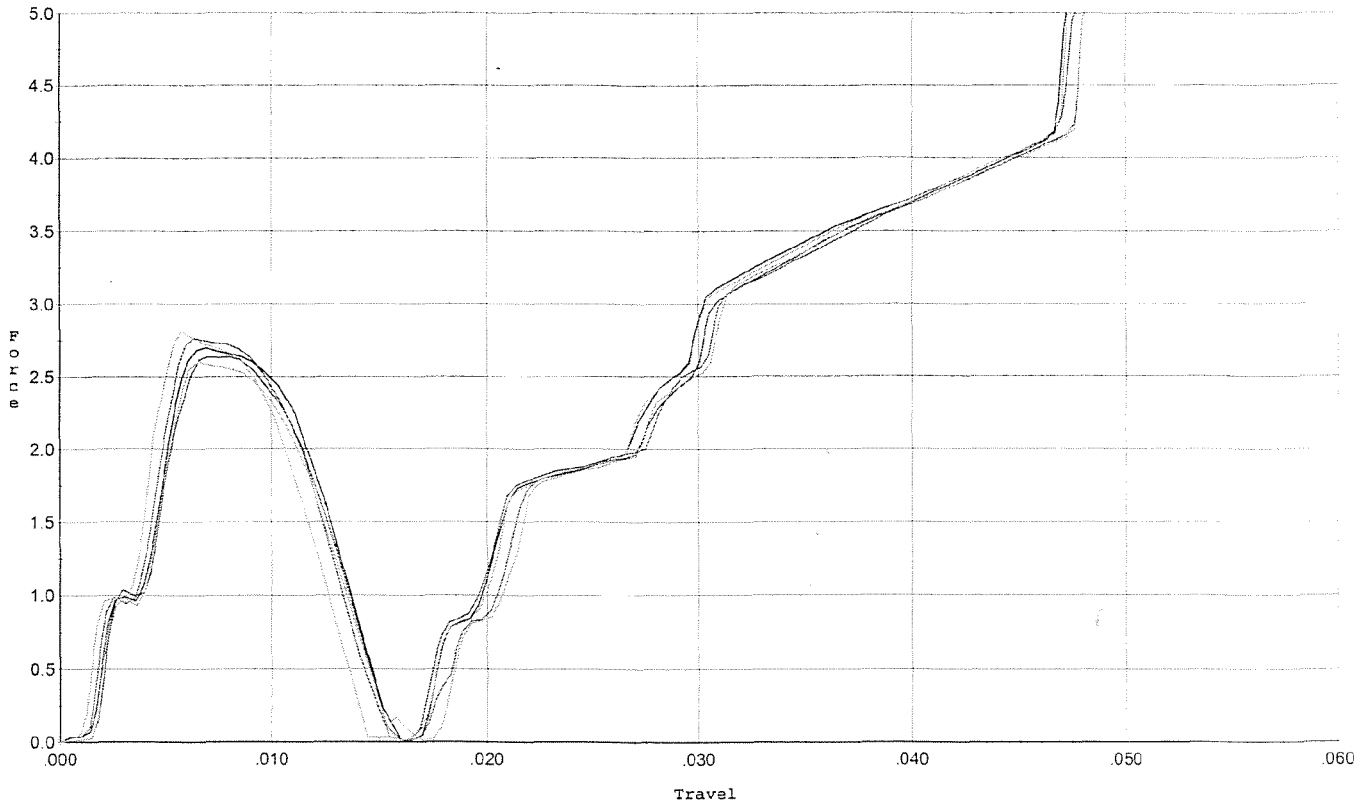
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.209	0.015	0.004	0.035	0.036		Set Trigger
2	3.993	0.015	0.004	0.035	0.038		Set Trigger
3	4.094	0.014	0.00	0.035	0.033		Set Trigger
4	3.947	0.014	0.00	0.034	0.036		Set Trigger
5	3.980	0.015	0.00	0.034	0.035		Set Trigger

A-4.04

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/28/2009

Model: M/24
 Serial No: Form #F005
 Trigger: reset to 2.5 lbs +/- .50 lb for final test



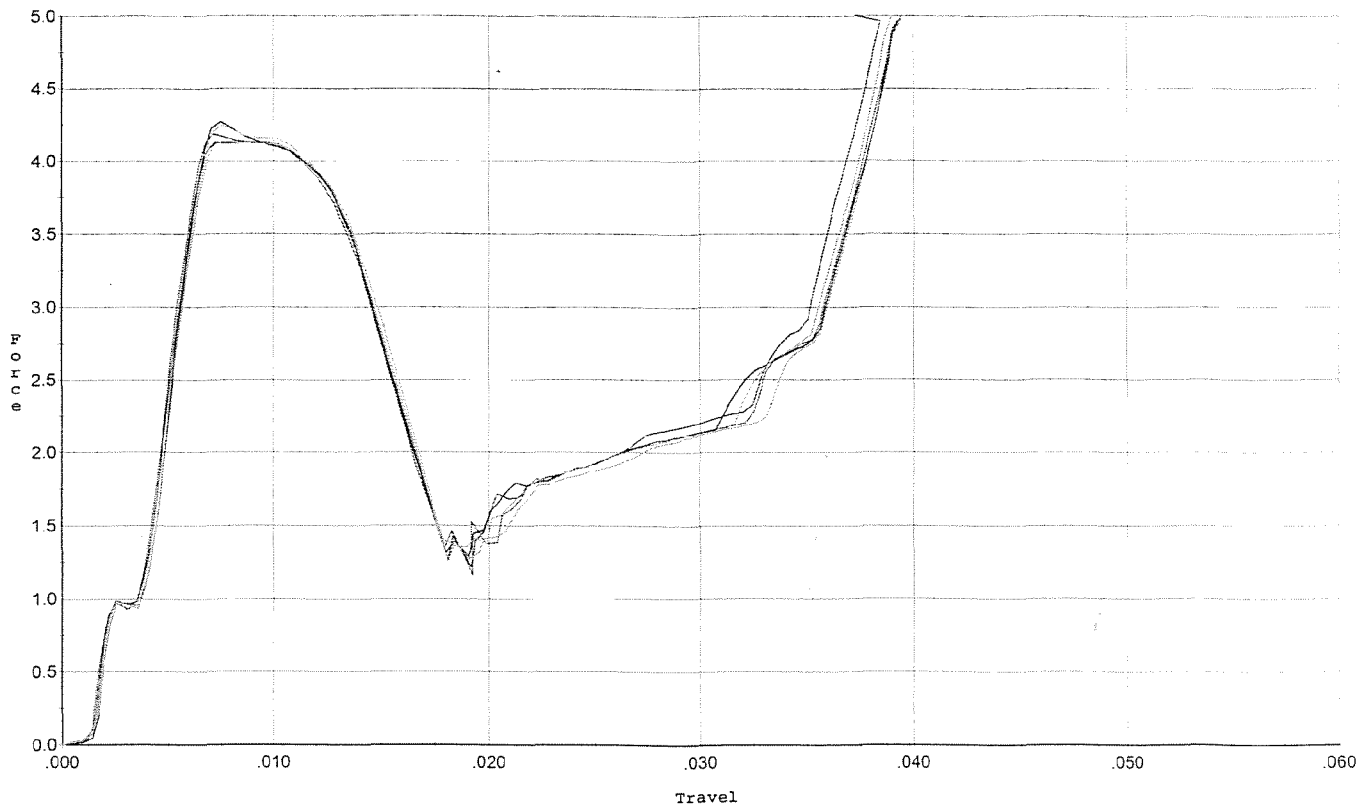
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.636	0.013	0.00	0.037	0.020		Set Trigger
2	2.699	0.013	0.00	0.037	0.020		Set Trigger
3	2.765	0.012	0.00	0.038	0.019		Set Trigger
4	2.809	0.012	0.00	0.038	0.020		Set Trigger
5	2.604	0.013	0.00	0.038	0.020		Set Trigger

A-2-70

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/28/2009

Model: M/24
 Serial No: Form #F005
 Trigger: set to 4.0 lbs +/- 1.0 lb for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.128	0.014	0.00	0.035	0.035		Set Trigger
2	4.274	0.014	0.004	0.036	0.034		Set Trigger
3	4.188	0.014	0.00	0.036	0.035		Set Trigger
4	4.135	0.015	0.004	0.035	0.038		Set Trigger
5	4.248	0.016	0.004	0.036	0.039		Set Trigger

17-4.19